

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011771**Date Inspected:** 29-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wuzhi Chang, Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG # TRIAL ASSEMBLY YARD

This QA inspector performed T-Rib dimensional survey and recorded horizontal and vertical offset along with Caltrans QA inspector (Mr.Manjunath S. Math) for below segment. Reports forwarded to team leader for further action

8CE-PP-69 + PP70 (CB Side) Side Plate 13~19.

This QA inspector performed dimensional check along with Caltrans QA Inspector (Mr.Manjunath .S Math) on Longitudinal Diaphragm (Bike Path Side) below segments and readings found to be in general compliance.

8CE-PP67+PP68.

This QA inspector performed dimensional Internal QA survey along with Caltrans QA Inspector (Mr.Manjunath . S Math) on Longitudinal Diaphragm (Bike Path Side & Counter Weight Side) below segments and readings found

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to be in general compliance.

6BW+6CW PP43-PP44

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (Cross Beam-6)

Repair Welding.

This QA inspector observed, ZPMC qualified welding personnel identified as 215248 perform Shielded Metal Arc Welding (SMAW), weld joint identified as CB202A-006-002; The Critical Welding Repair Report (CWR) was B-CWR997. ZPMC CWI identified as Mr. Zheng Zhi Wei. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-2G (2F) Repair

Segment# 6CW-7AW

This QA inspector observed, ZPMC qualified welding personnel identified as 067949 perform Flux Core Arc Welding (FCAW), weld joint identified as SEG031F-011, ZPMC QC identified as Mr. Feng Ya Jun. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2232-TC-U4b-F

This QA inspector observed, ZPMC qualified welding personnel identified as 068091 perform Flux Core Arc Welding (FCAW), weld joint identified as SEG031F-011, ZPMC QC identified as Mr. Feng Ya Jun. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2132

This QA inspector observed, ZPMC qualified welding personnel identified as 068091 perform Flux Core Arc Welding (FCAW), weld joint identified as SEG031F-011, ZPMC QC identified as Mr. Feng Ya Jun. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2132

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Prabhune,Manoj

Quality Assurance Inspector

Reviewed By: Miller,Mark

QA Reviewer